

**Work Order ID 74548**

Tuesday, October 04, 2011 9:57:16 AM



Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: M L J

Date: 11/10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3197

Rev B

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

SL 11-10-14

⑥

Ø

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197□2-Machine D3197-1 as per Folio FA340  
and Dwg D3197□3-Deburr

SL 11-10-17

⑥

Ø

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

SL 11-10-17

⑥

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

JL 11-10-14

6

φ

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

B.O 11/10/17

6

φ

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

6x φ M-L 11/10/17

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180



Small Fab

Small Fab

Small Fab

0.00

Memo

Assemble D3197-041 as per Dwg D3197

0.00

6xØ m/d 11/10/11

BR 11-10-19

ES 11/11/01 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 74548**

Tuesday, October 04, 2011 9:57:16 AM



Page 4

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Revision ID:

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Item Name: Bar Assembly

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 - 11 - 02 (6)

200

Identify as per dwg &amp; Stock Location: 5260

0.00



Packaging

Memo

0.00

Packaging

11 - 11 - 02

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/03

11/11/02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Tuesday, October 04, 2011 9:57:21 AM

**Parent Item:** D3197-041





**Parent Item Name:** Bar Assembly

**Start Date:** 9/30/2011**Required Date:** 10/14/2011

**Start Qty: 6.00**

**Required Qty: 6.00**

**Comments:** IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev:B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 		Purchased	No			100	Each	86.0000	2	12			
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST292		86							
				100151		86							
AN960JD10 	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	36			
Washer													
D2690-5 		Manufactured	No			180	Each	11.0000	2	12			
Lanyard Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST020		11							
				73321		<del>11</del> 10							
D3242-1 		Manufactured	No			180	Each	12.0000	2	12			
Tag													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST044		12							
				73502		12							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 04, 2011 9:57:21 AM

Work Order ID: 74548



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured No

180

Each

12.0000

2

12



PIP PIN



*9/30/11/01*

Location

Loc Qty

Loc Code

GA

9

73503

9

ST062

3

70271

3

*B 75792*

*9*

M7075T73R1.000

Purchased

No

180

f

48.7150

2.42

18.15



7075-T73 Rd Bar 1.00

*SL 11-10-13*

Location

Loc Qty

Loc Code

MAT012

48.715

115165

2.7

116405

4.54

116604

2.25

116835

2.32

116962

0.905

118305

12

119049

24

*18.2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

Tuesday, October 04, 2011 9:57:22 AM

Work Order ID: 74548



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

180

Each

11,174.00

2

12



Nut



*Handwritten signature and date: 9/30/11*

Location

Loc Qty

Loc Code

ST300

2174

117441

16

117601

68

117885

97

118451

993

118927

1000

ST516

6000

119017

6000

ST518

3000

119075

3000

*Handwritten number: 12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# RELEASED

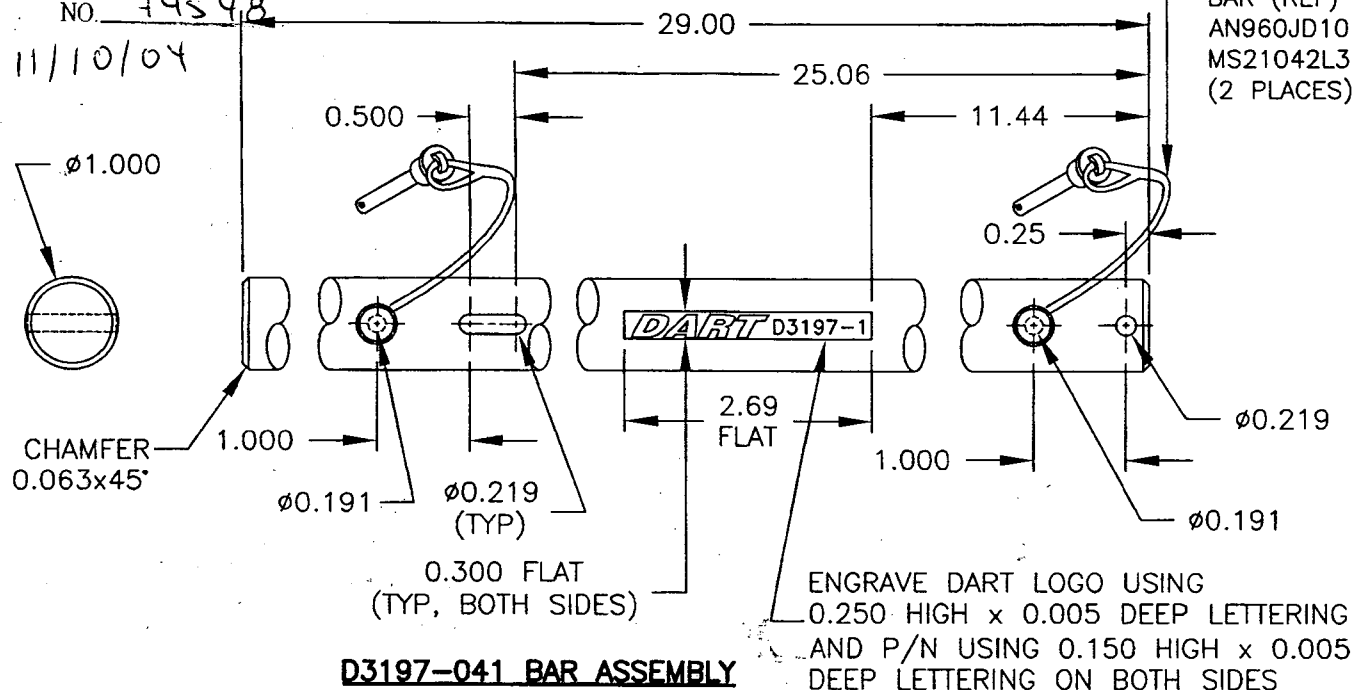
# DART

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74548

M.L.J

11/10/04

D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



## D3197-041 BAR ASSEMBLY

### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	SCALE
A	03.07.01	NEW ISSUE		
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		
		DRAWING NO.	D3197	SHEET 1 OF 1
		REV. B		



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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